Work Orde June-18-14 1:56		230		*12	1230*							Page 1
Item ID: Revision ID:	D3462-1		4	Accept	*N900	040	100	<b>)</b> *	Setup		171	S1*
Item Name:	Bracket Assemb	ly								Stop	*N	S2*
Start Date: Required Date: Reference:		Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item :							
Approvals:	Process Plan:	: MLS	Date: 14-06-18  _ Date:	Tooling: _ SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center ID	(	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp
Draw Nbr	Revisi	ion Nbr										· · · · · · · · · · · · · · · · · · ·
D3462	Rev C	,									_	
100 <b>*1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\</b>	I	FLOW WATER JET		0.00				(b)			DAS <b>46</b> 9-89	14/08/09
FLOW CNC Waterje	t	Dwg Rev:_ Prog Rev:_	-	0.00								
*110		QC2- Inspect parts off	machine FAI/FAIB	0.00				(b)			DAS <b>46</b>	
QC		Memo		0.00							9-89	

Memo

Quality Control

WORK ORDER NON-CONFORMANCE / UPDATE  Work Order:  Work Order:  Part No.  NCR No.  Rework Use-as-is Suspected Unapproved Suspected Unapproved Cause Date  Description of work order update Cause Date Step Qty  Description of work order update Or or non-conformance Chief Eng Description  Work Order update Skid-tube Crosstube Crosstube Water Jet Water Jet Engineering Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Finishing Rec/Store/Packaging Supplier  Other Composite  Ochief Eng Description Description Description Description Date Verification QC Inspects  Ochief Eng Description Doc/Data Equip/Tooling Handling/Pro	T	TOA!				_			_			Date:			DQA:
Work Order:    Part No.	PACE	AEROS				RMANCE / UP	ONFO	N-C	WORK ORDER NON			_			
Work Order:    Part No.			date only	ork Order up	W		1					Date:			QA Closed:
Part No.    Part No.			PROCESS	PARTMENT	AGAINST DE				DISPOSITION					or∙	Work Orde
Part No.    Cause   Date   Step   Qty   Or non-conformance   Equip/Tooling   E		Engineering	Water Jet		Crosstube	Skid-tube		П	Rework		<u> </u>		· · · ·		Work Orac
NCR No.    NCR No.   Suspected Unapproved   Suspected Unapproved Unapproved   Suspected Unapproved U	-	-	d. Eng. Coor.	Pro		<b>⊢</b>	] ,	-	<u> </u>					No.	Part N
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Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling			Supplier		Composite	Large Fab			Suspected Unapproved					No	NCR N
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling		<del>,</del>									,		-		
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Operator														Щ	Operator
Offset/Setup														Ш	Offset/Setup
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Crimp/Kink/Kipple/ Wave	ulled	4	-	-			-	-		·  -	wave	к/кірріе	-	$\vdash$	
		]	L Vrong	-		•		<b>-</b>	<b>–</b>	-					
Crushing Countersink Misaligned/off center Positioned Wrong  Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other		Other		4	<del> </del>	=		$\vdash$		-		•	_		
Inspection Strip in Tube Drawing Misread		1 2 2		J. 55, 2000)	L		-	$\vdash$		$\vdash$	Tubo			-	
Marks/Chatter Drill Holes Off-set			,				-	-	<b>-</b>	-	iuse		-	-	
Turning Sequence Finish Out of Calibration							-	 		-				-	
Wave/Twist in Tube Fit/Function Out of Sequence							-	H	<b>—</b>			•	_		

Work Ord June-18-14 1:5		21230		*121	230*							Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D3462-1  Bracket Asse 6/18/14 :: 6/18/14	embly Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N900 Cust Item I Customer:		100	)*	Setup	Start Stop		S1* S2*
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:	_	]	Run	Start Stop	^I <i>V</i> I	R1* R2*
Sequence ID/ Work Center I 120 *1 20* QC Quality Control	ID	Operation Description QC8- Inspect parts - seco	and check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp DAS 38 9-89
150 *150* Packaging Packaging		Identify as per dwg & St  Memo  *****STOO	ock Location: WAC	0.00				6>	<	DAS 28 9-89	AU	6 <u>11201</u> 4

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QC21- Final Inspection - Work Order Release

0.00

\*160\*

Memo

**Quality Control** 

0.00

MUJ 14-08-12

DQA:			Date:	_										TAART
						<b>WORK ORDER NON</b>	-CO	ONFO	RMANCE / UP			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Ord	er:					Dawark	1		Skid-tube	Crosstube	1	Water Jet		Engineering
Part i	۷o.					Rework Scrap			Machining	Small Fab	=	d. Eng. Coor.		Quality
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Offset/Setup														
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Landi	ng (	1			_	General	_	1 .		_	٦	. 1	$\overline{}$	
		Bending				Bend		-	Program	<u> </u>	Outside Dim		-	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric		BOM/Route	_	Grain			Over/Under		-	Set-up
	匚	Cracks				Broken/Damage/Defect	$\vdash$	Hardwa		<u> </u>	Part Incorre		-	Temperature/Cure
	匚	Crimp/Kii	nk/Ripple	/Wave	<u> </u>	Burrs	<u></u>	1 '	ion Incomplete/Und		Part Lost/Mi	ssing		Weld
	<u>_</u>	Cuffs			L	Contamination	$\vdash$	4	tions Incomplete/U	nclear	Part Moved	İ		Wrong Stock Pulled
	$ldsymbol{ld}}}}}}$	Crushing			L	Countersink		-1	gned/off center		Positioned V			
	$ldsymbol{le}}}}}}}$	Heat Trea			<u> </u>	Cut Too Short		Mislabe		L	Power Loss/	Surge	Ш	Other
	L	Inspectio	n Strip in	Tube		Drawing	$\perp$	Misrea			4			· · · · · · · · · · · · · · · · · · ·
		Marks/Cl	natter			Drill Holes	$\perp$	Off-set			<del></del>			
	_	Turning S	Sequence			Finish		4	Calibration					*******
	1	Wave/Tw	vist in Tub	эе		Fit/Function		Out of	Sequence					

**Picklist Print** 

June-18-14 1:56:48 PM

Work Order ID: 121230 \*121230

Parent Item: D3462-1

\*D3462-1\*

Parent Item Name: Bracket Assembly

**Start Date:** 6/18/14

Required Date: 6/18/14

Page 1

Start Qty: 6.00

Required Qty: 6.00

**Comments:** 

IPP REV. A 05.11.18 NEW ISSUE EC IPP Rev:B Now on Waterjet 06-06-16 JLM

esr rev B 08.07.15 ecn 1049 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	133.3000	0.095	1	Γ	DAS	
*M304S1	IGA*								**			46 -89	14/08/09
				Location		Loc (	<u>Oty</u>	Loc Code				<b></b>	
				MAT020		1:	33.3		_		_		
					122521		30				_		
				•	M128254	10	03.3			0.5	_		

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DQA:			Date:			WORK ORDER NON	~	21150						TDART
QA Closed:			Date:			WORK ORDER NON	-((	JNFO	RIVIAINCE / UI		Wor	k Order up	odate only	AEROSPACE
Manle Onde						DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS	
Work Orde	er: –					Rework	ıl		Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	$\forall$	Pro	d. Eng. Coor.	Quality
raiti	•0. –					Use-as-is			noforming	Finishing	Н		re/Packaging	Other
NCR N	lo					Suspected Unapproved			Large Fab	Composite		•	Supplier	
														<del></del>
Root					Desc	ription of work order update		nitial	Act			Sign &		
Cause	$\dashv$	Date	Step	Qty	<u> </u>	or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
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Operator						•								
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Process	$\dashv$													
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Unapproved	i		<u> </u>	<u> </u>	<u> </u>		EA	III T CA'	TEGORY					
Landii	na G	025				General	-1 /	OLI CA	120011					
Lanuii		Bending				Bend	Г	Teolio/F	Program		$\Box$	Outside Dim	ensions [	Pressure/Forced
	-	Centre No	nt Concer	ntric		BOM/Route		Grain	. 08		$\vdash$	Over/Under	<u> </u>	Set-up
	-	Cracks	or concer	1010		Broken/Damage/Defect		Hardwa	are		-	Part Incorre	<u></u>	Temperature/Cure
	$\vdash$	Crimp/Kir	nk/Ripple	/Wave		Burrs	-	1	ion Incomplete/Ur	ngualified	Пr	Part Lost/Mi	issing	Weld
	-	Cuffs	,, p	,, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		Contamination	H	4 '	tions Incomplete/U	*		Part Moved		Wrong Stock Pulled
	${oldsymbol{ o}}$	Crushing				Countersink	H	-1	gned/off center		-	Positioned V	Vrong	<b>_</b>
		Heat Trea	ıt			Cut Too Short		Mislab	_		-	ower Loss/		Other
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	-	Wave/Tw				Fit/Function		Out of	Sequence					

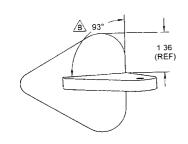
D3065-5DART AEROSPACE LTD	Work Order:	121250
	Part Number:	D3462-1
Description: Base  Inspection Dwg: D3462 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

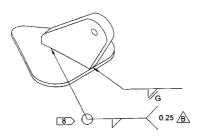
x	First Article	Prototype

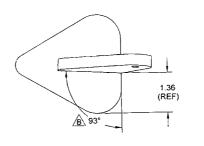
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.58	+/-0.030	3.59	V		V-Jkm-01	
3.36	+/-0.030	3.35				
0.125	+/-0.010	0.117				
				•		
-						
	DAS					

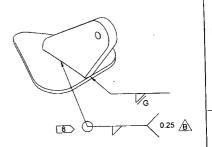
-		B.4.	Change	Revised by	Approved
	Rev	Date	Change	KJ/JLM 1.A	
	Α		New Issue	KJ/DD A	13
	В	08.07.24	Dimensions updated per Dwg Rev C	LYSIDD SIX	د اللهم

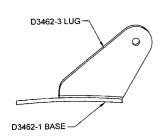


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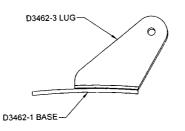


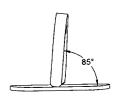












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## D3462-041 BRACKET ASSEMBLY

SHOP COLY RETURN TO

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UNCONTROLL CONTROLL SUBJECT TO A 1 1 10 1 1 1

WITHOU ... " Z

WORK ON MUJ NO. 121230 MUJ 1406-18

11Y 041	-042	P/N	DESCRIPTION
X	7.3	D3462-041	BRACKET ASSEMBLY
	Х	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042"
USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.75 lbs (TYP)
8) WELDING: PER DART QSI 004

## D3462-042 BRACKET ASSEMBLY



SHOW	VIEWS OF D346	2-041 & D3462-042, UPDATE DWG	DC	07.10.24			
			RF	05.12.05			
			RF	05.09.20			
DESCR	IPTION		BY	DATE			
<b>V</b>		DART AEROSPA	ACE	LTD			
V	THE FORDE	HAWKESBURY, ONTAR	IO, CAN	ADA			
ED	100	DRAWING NO.		REV. C			
PPR.	200	D3462		SHEET 1 OF 2			
VED	7.0	TITLE		SCALE			
PR.	-##			1:2			
	10.24	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENTS PRIVATE AND COMPRISHMAL HOURS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PUMPOSE OR COMED OR COMMINIONED TO THAT OTHER PERSON WITHOUT WHATEN PRIMASEDINF FOR MAIN ERROSPACE LTD					
	REVISE NEW IS DESCR N N (ED PPR. DVED	REVISE DIMENSIONS NEW ISSUE DESCRIPTION N N INCLUDE DEPT. DED DED DED DED DED DED DED DED DED DE	NEW ISSUE  DESCRIPTION  DESCRIPTION  DESCRIPTION  DESCRIPTION  DART AEROSP  HAWKESBURY, ONTAR  DRAWING NO.  D3462  DRAWING NO.  D3462  TITLE  BRACKET ASSEMBL  O7.10.24	REVISE DIMENSIONS RE NEW ISSUE DESCRIPTION N DART AEROSPACE HAWKESBURY, ONTARIO, CANA DRAWING NO. D3462 VED DR			

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60° (TYP) 3.36 R0.82 (TYP) D3462-1F FLAT PATTERN

- R0.55 --- 0.375 2.55 Ø0.257 (DRILL "F") 1.98 B R20.0±0.1 R0.50 -0.08 X 45° CHAMFER (TYP)

R20.0±0.1

D3462-1 BEND DETAIL (MAKE FROM D3462-1F)

NOTES:
1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK PER MIL-S-5019 (ANNEALED), 2B FINISH (REF. DART SPEC. M304S11GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.28 lbs

NOTES:
1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.47 lbs

D3462-3 LUG



DESIGN DRAWN	PA SAIL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	hete.	DRAWING NO.	REV. C
MFG. APPR.	20	D3462	SHEET 2 OF 2
APPROVED	10000	TITLE	SCALE
DE APPR.	AND THE	BRACKET ASSEMBLY_	1:1
DATE 07.10.24		COPYRIGHT © 2005 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND COMPORTING AND IS SUPPLIED ON THE EXPRESS CONSTITUTION THAT IT IS  HOT TO BE USED FOR ANY PARROES ON COMPUTE AND TO ANY OTHER PERSON WITHOUT  WHATEVER PROMISSION FROM DAILY ARROSPACE LTD.	

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